

Appl. No. 09/678,923  
Amdt. dated January 31, 2005  
Reply to Office Action of November 30, 2004  
Attorney Docket K-1633

**Amendments to the Claims:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**LISTING OF CLAIMS:**

1. (previously presented): An all effective cutting tool for cutting a workpiece comprising:  
a tool body having an outer surface thereon and a central axis therein and including at least a first and second spiraling flute in the outer surface, each flute including a plurality of inserts secured therein to define an axial rake angle, wherein the axial rake angle of the inserts varies between flutes and within each flute to provide single flute all effective cutting.
2. (original): The cutting tool of claim 1 wherein all of the inserts on the entire tool body are identical.
3. (original): The cutting tool of claim 1 wherein the tool body includes three spiraling flutes, wherein each spiraling flute has a first, second and third axial rake angle.
4. (original): The cutting tool of claim 3 wherein all of the inserts on the entire tool body are identical.
5. (previously presented): The cutting tool of claim 4 wherein each insert has an actual length longer than the cutting edge, and the actual lengths of adjacent inserts in any single flute do not circumferentially overlap.
6. (previously presented): The cutting tool of claim 1 wherein the inserts each have a cutting edge and the cutting edges on adjacent inserts in any single flute do not circumferentially overlap.
7. (original): The cutting tool of claim 1 wherein the inserts each have a cutting edge and the cutting edges on inserts with differing axial rake angles have differing cutting edge lengths.
- 8-14. (cancelled).
15. (New): The cutting tool of claim 1 wherein the axial rake angles of at least three adjacent inserts within each flute either progressively decrease then increase or increase then decrease.